

Date: Tuesday, 04/07/2006 1:58:03 PM
 User: Linda Lacelle

Process Sheet

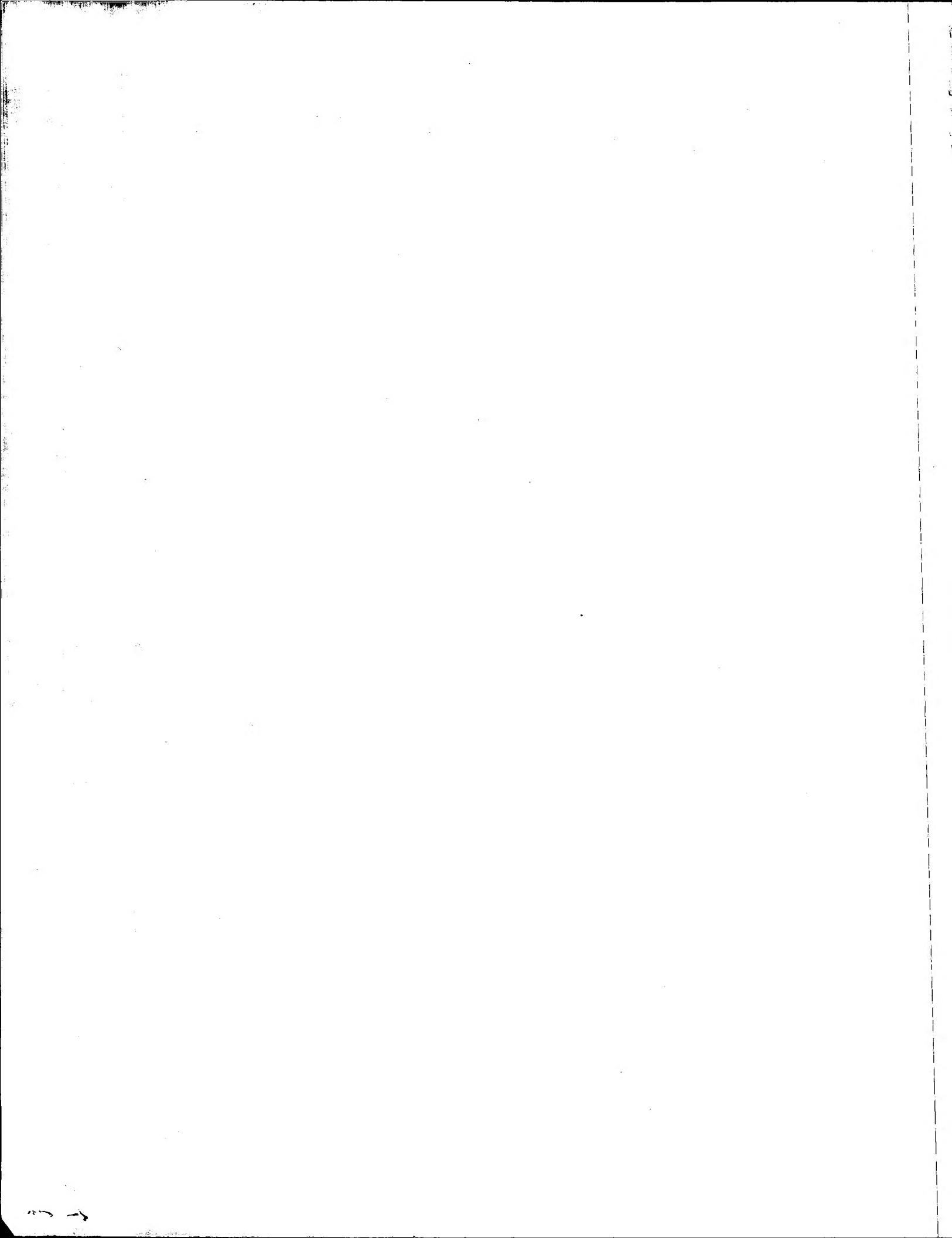
Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	STEP LEG		
Job Number	27756B			Part Number	D2278		
Estimate Number	10353			Drawing Number	D2278 REV E		
P.O. Number	N/A			Project Number	N/A		
This Issue	04/07/2006	S.O. No.	N/A	Drawing Revision	E		
Prshrt Rev.	NC			Material	N/A		
First Issue	28/06/2006	Type	SMALL /MED FAB	Due Date	12/07/2006		
Previous Run	25395B			Qty:	40	Um:	Each
Written By	<u>See Comment Below</u>						
Checked & Approved By							
Comment	Est Rev:A New Issue 05-11-07 JLM Est Rev:B Now 6061-T6 06-06-23 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S080	6061-T6 .080 Sheet
	Comment: Qty.: 1.0306 sf(s)/Unit Total : 41.2230 sf(s) Material: 6061-T6 sheet (QQ-A-250/8) 0.080" Thick (M6061T62S.080) Identify as D2278 Batch: 0101178	
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET	 <i>MM 06/07 13</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	 <i>MM 06/07 13</i>
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	 <i>06/07.20</i>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr	 <i>SAD 06/07/27 M.F. 06/07/27.</i>



Date: Tuesday, 04/07/2006 1:58:04 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP LEG

Job Number: 27756B

Part Number: D2278

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MF 06/07/27 40

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SAD 06/07/27 40

8.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SAD 06/07/31 40

9.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

40 Doc/08/01

Job Completion



C Lole 08/01

Date: Wednesday, 6/28/2006 4:18:31 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: STEP LEG		
Job Number	: 27756B			Part Number	: D2278		
Estimate Number	: 10353			Drawing Number	: D2278 REV E		
P.O. Number	:			Project Number	: N/A		
This Issue	: 6/28/2006 S.O. No. :			Drawing Revision	: E		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : SMALL /MED FAB			Due Date	: 7/12/2006 Qty: 40 Um: Each		
Previous Run	: 25395B						
Written By	: <u>KJ</u> 06 06 29						
Checked & Approved By	:						
Comment	: Est Rev:A New Issue 05-11-07 JLM						
	Est Rev:B Now 6061-T6 06-06-23 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6S080	6061-T6 .080 Sheet	
2.0	SHEAR	Comment: SHEAR Cut blanks: (16.61" x 8.51") +000/-0.020" (grain along 8.51") for each leg	
	HAAS1	HAAS CNC VERTICAL MACHINING #1	<i>06 07 13</i> (40)
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: 27756B		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/07/12	2.0	6 pieces cut with wrong grain direction	JH JG AD ER	Destroy scrap pieces and cut new ones	M 06/07/12	/ / 06/07/12	DS 06/07/12	DS 06/07/12

Part No: D2278

PAR # JIA

Fault Category: Prod / Machined

NCR: Yes No DQA:

Date: 06/08/12

NOTE: Date & initial all entries

QA: N/C Closed:

Date: 06.08.03

Date: Wednesday, 6/28/2006 4:18:31 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP LEG

Job Number: 27756B

Part Number: D2278

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0 QC3-

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

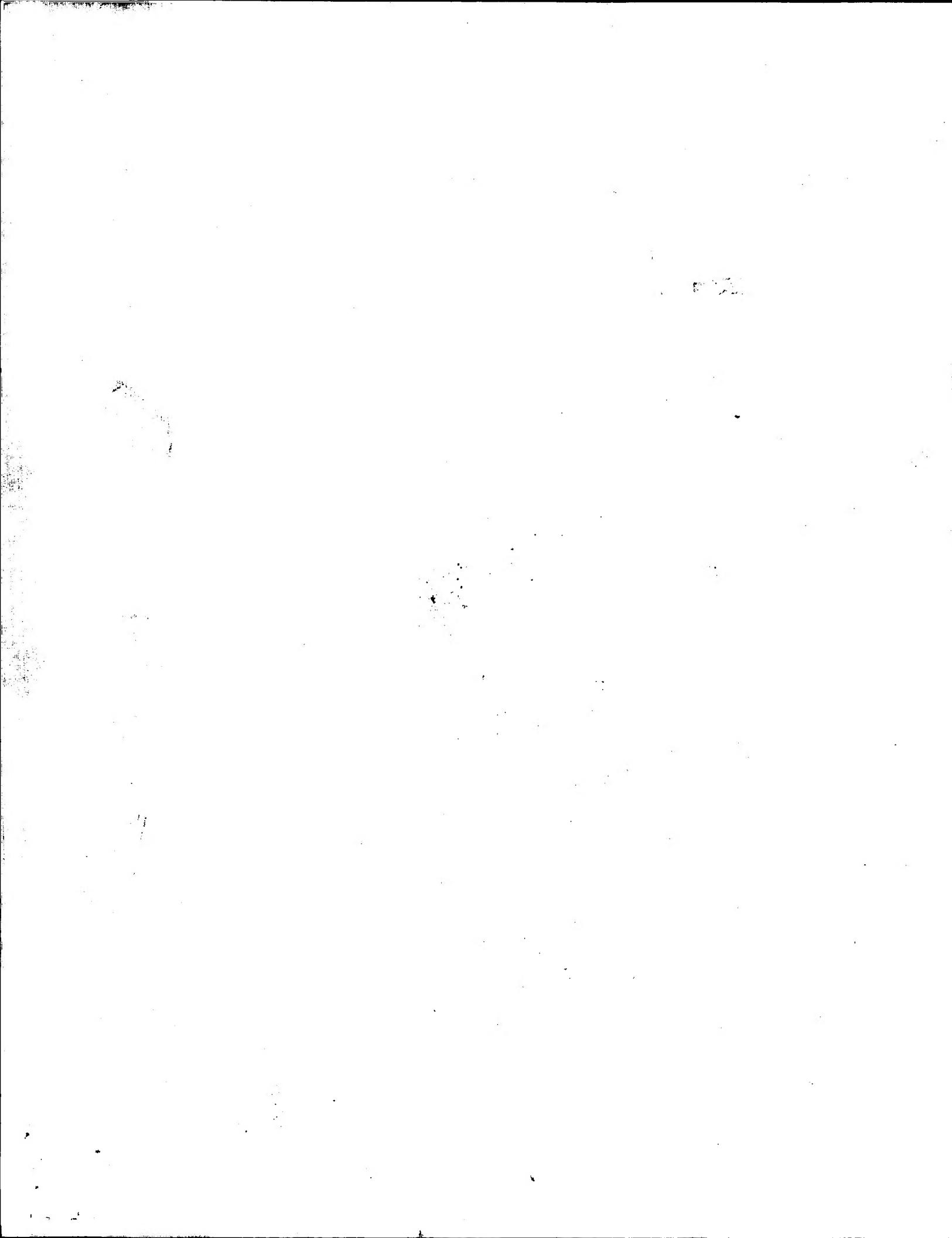
DART AEROSPACE LTD	Work Order:	27756B
Description: Leg	Part Number:	D2278
Inspection Dwg: D2278	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	06.07.18	Date:	06.07.18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.10.12	New Issue P/O D2582	KJ/JLM	
B	06.03.08	Dwg Rev. changed	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM	

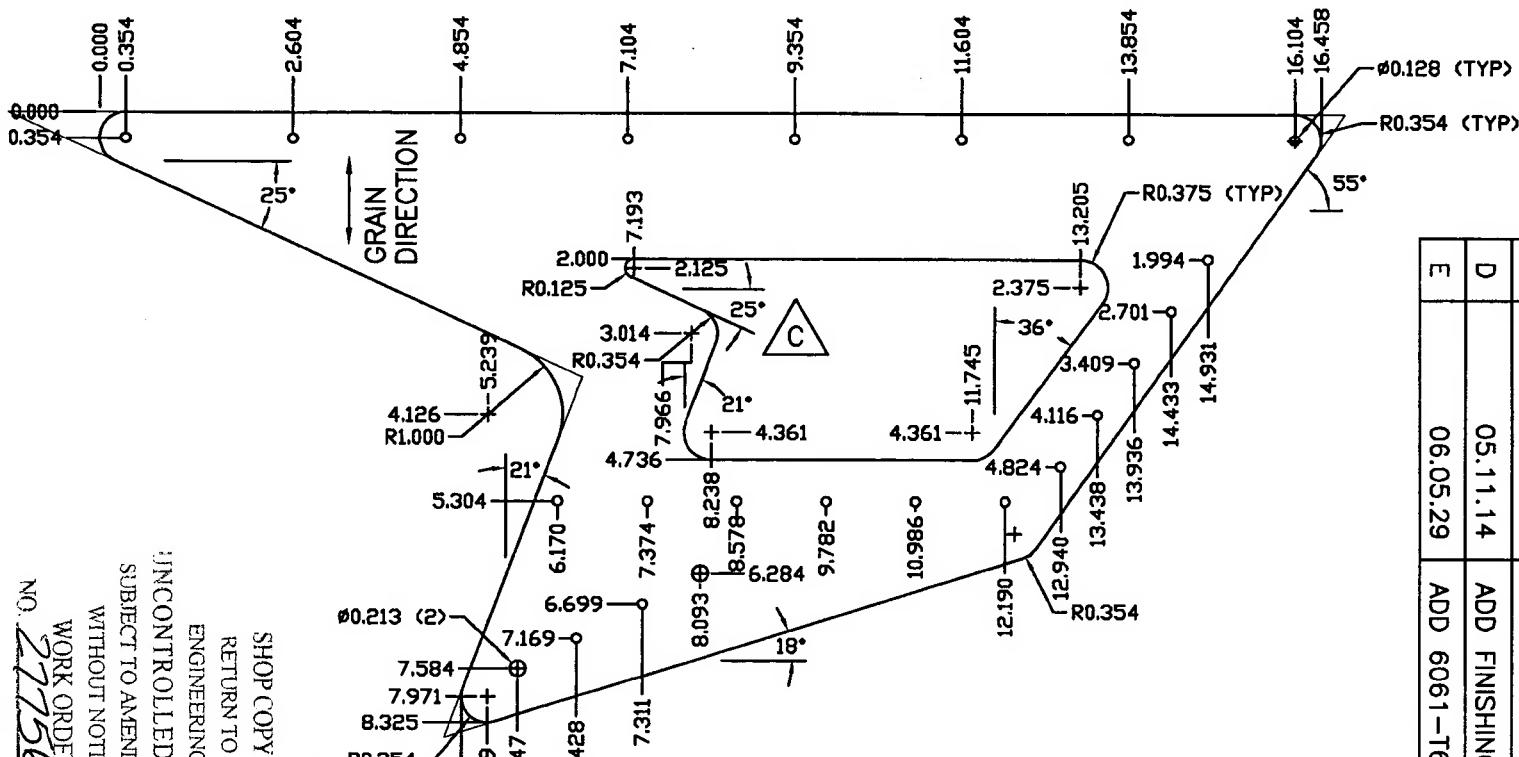


RELEASED

06.06.20 ~~11~~

DART

DESIGN BW		DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2278	REV. E SHEET 1 OF 1	
DATE 06.05.29	TITLE LEG	SCALE 1:2.5		
C D E	95.02.16 05.11.14 06.05.29	CHANGED RADIUS TO 0.354 ADD FINISHING NOTE ADD 6061-T6 MATERIAL		



1) MATERIAL: 6061-T6 ALUMINUM SHEET (PER QQ-A-250/11 OR AMS 4025 OR
AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
OR

5052-H32 ALUMINUM SHEET (PER QQ-A-250/8 OR AMS 4016)
0.080" THICK (REF DART SPEC M5052H32S.080)

2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

3) ALL DIMENSIONS ARE IN INCHES
4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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